

Work Order ID 61879

Wednesday, September 08, 2010 3:08:30 PM



Page 1

Item ID: D4164-041

Accept



Setup Start



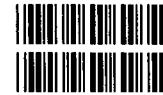
Revision ID:

Item Name: Nut Plate Adapter Assembly

Stop



Start Date: 9/8/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *10908*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4164	A

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

6061 .040

Memo

1-Cut as per Dwg D

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

*1B10-9-15**110*

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

1B10-9-15

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

*8/10/09/17**counts**7/10*

Work Order ID 61879

Page 2

Wednesday, September 08, 2010 3:08:30 PM

Item ID: D4164-041

Accept



Setup Start



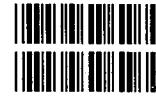
Revision ID:

Item Name: Nut Plate Adapter Assembly

Stop



Start Date: 9/8/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID**

130



Small Fab

**Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

10/09/21

(cont'd)
+110

141



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

= 10/09/21

110 9

Work Order ID 61879

Wednesday, September 08, 2010 3:08:30 PM



Page 3

Item ID: D4164-041

Accept



Setup Start



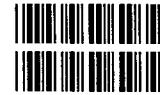
Revision ID:

Item Name: Nut Plate Adapter Assembly

Stop



Start Date: 9/8/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID**

160



QC

Quality Control

**Operation
Description**

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

BK 10-9-21

Tool #

Plan
CodeAccept
Qty

110

Reject
Qty

0

Reject
NumberInsp.
Stamp

170



Small Fab

Small Fab

0.00

0.00

Small Fab

Memo

Install Nut plate as per Dwg

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

S. 10/9/27

counts

+110

10/8/09 *27* *110*

10/8/27

Work Order ID 61879

Page 4

Wednesday, September 08, 2010 3:08:30 PM

Item ID: D4164-041

Accept



Setup Start



Revision ID:

Item Name: Nut Plate Adapter Assembly

Stop



Start Date: 9/8/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 250Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>250</u>	0.00							
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Picklist Print

Wednesday, September 08, 2010 3:08:34 PM

Page 1

Work Order ID: 61879



Parent Item: D4164-041



Parent Item Name: Nut Plate Adapter Assembly

Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A NEW ISSUE 10-09-07 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased		No		100	sf	86.7300	0.001	0.105263	1.5		

6061-T6 .040 Sheet

Location	Loc Qty	Loc Code
MAT21	86.73	
113004	86.73	

1810-9+15

no

X MS21059L3



Purchased

No

Location	Loc Qty	Loc Code
113004	37.0000	1
		100

113004

Nut Plate

Location	Loc Qty	Loc Code
ST301	37	
114718	37	

M115727(2W)

M115708(83W)

MS20426AD3-3



Purchased

No

Location	Loc Qty	Loc Code
ST301	37	
114718	37	
	5,021.000	2
		200

M114718(6W)

Rivet

Location	Loc Qty	Loc Code
ST316	5021	
19099	4774	
7681	247	

87-197
#23

111099

DART AEROSPACE LTD	Work Order:	
Description: NUT PLATE ADAPTER ASSEMBLY	Part Number:	D4164-041
Inspection Dwg: D4164-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	109-15	Date:	10/05/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8

7

6

5

4

3

2

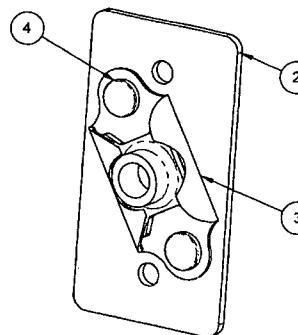
1

D

C

B

A



D4164-041 NUT PLATE ADAPTER ASSY

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4164-041	NUT PLATE ADAPTER ASSEMBLY
2	1	D4164-1	NUT PLATE ADAPTER
3	1	MS21059L3	NUT PLATE
4	2	MS20426AD3-3	RIVET

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHDRAWN

WORK ORDER

NO. 41879

PD10-9-08

RELEASED
2010-09-07
M

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4164-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.006 lbs

A	NEW ISSUE	RF	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	KB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D4164 REV. A	
CHECKED	<i>[Signature]</i>	SHEET 1 OF 2	
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	NUT PLATE ADAPTER ASSY	NTS
DE APPR.	<i>[Signature]</i>	DATE 10.07.22	

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

8

7

6

5

4

3

2

1

A

8 7 6 5 4 3 2 1

